

Date: Tuesday, 4/17/2007 11:05:07 AM
User: Kim Johnston

Process Sheet

82412
803 07107/09

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP
Job Number : 31833 Estimate Number : 11119
P.O. Number : Part Number : D30411
This Issue : 4/17/2007 S.O. No. : Drawing Number : D3041 REV.C
Prsht Rev. : NC Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS Drawing Revision : C
Previous Run : 26217 Material :
Written By : Due Date : 4/24/2007 Qty: 50 Um: Each
Checked & Approved By : 07.04.17
Comment : Est:A 01.07.11 New Issue SM
est B 07.04.09 rev.c dwg EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0875 f(s)/Unit Total: 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: 330062

En

07/04/27

(X50)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

En

07/04/27

(X50)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

Issue P.O. 3463

Machine per drawing D3041 Rev. C

07/04/30

(50)

4.0 Q02 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Review + inspect for transit damage

5.0 Q05 SECOND CHECK



Comment: SECOND CHECK

inspect lower

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/07/04	14	Split w/o	SK	07/07/04	39 6			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FK 07/05/14

(50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M.L. 07/05/15

(50X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

M.L. 07/05/16

(60X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FK

07/05/17

(50)

10.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

1 D2611 Bearing

B320914 (20)

B3 31888 (30)

SB 08/03/11 (16)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

SB 08/03/11

p70

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/11 (46)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST465

AS 08/03/12 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3041-1 PAR #: NA Fault Category: Prod / FAB. Ass' Med & Smal NCR: Yes No DQA: LD Date: 08/03/11
 QA: N/C Closed: _____ Date: _____

NCR: <u>3183-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/03/11</u>	<u>11</u>	<u>4 pins were snapped because didn't have good Jig for. Jig was made</u>	<u>[Signature]</u> <u>Chief Eng</u>	<u>Scrap + destroy</u>	<u>SB</u> <u>08/03/11</u>	<u>[Signature]</u> <u>08-03-11</u>	<u>[Signature]</u> <u>08-03-11</u>	<u>[Signature]</u> <u>08-03-11</u>

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/13

Job Completion



mi 2008/3/13

6

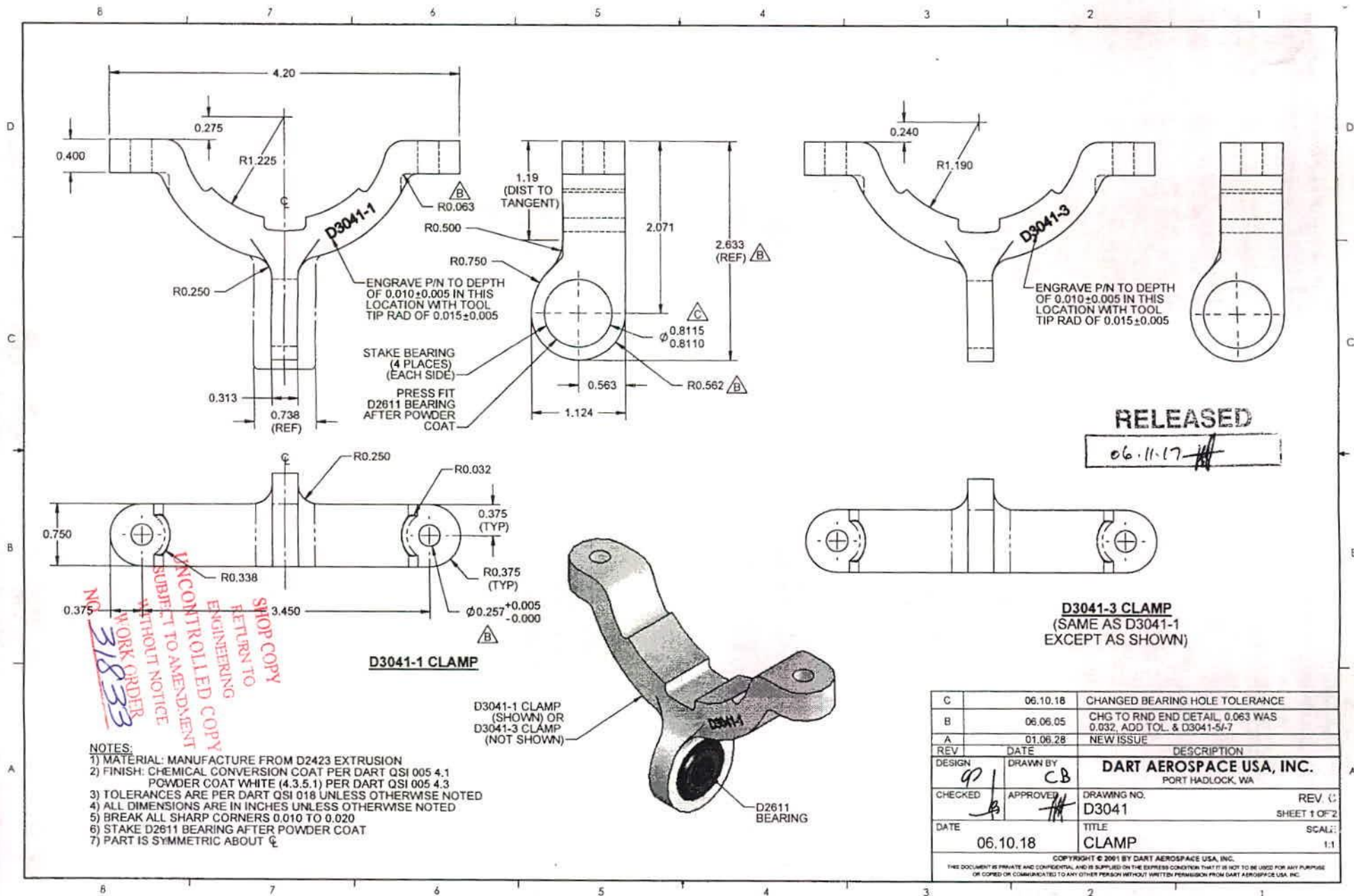
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

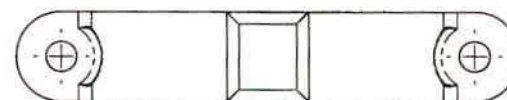
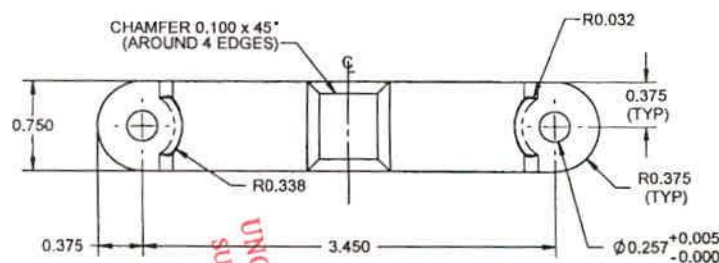
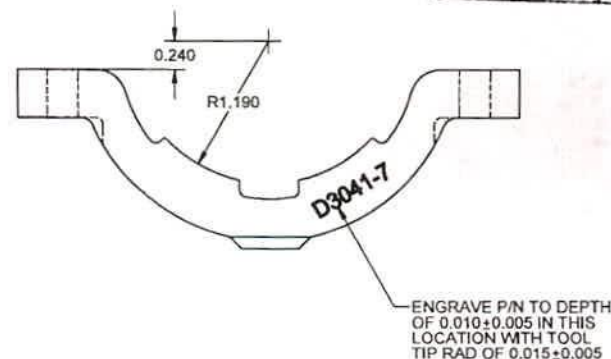
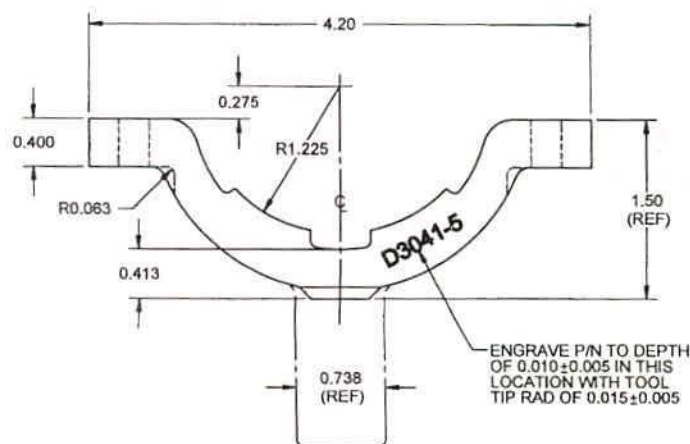
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

06.11.17



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

D3041-5 CLAMP



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) PART IS SYMMETRIC ABOUT C

NO 31833
WORK ORDER
SUBJECT TO AMENDMENTS
UNCONTROLLED
ENGINEERING
RETURN TO
SHOP COPY
NO 31833

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
901	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
13	11	D3041	SHEET 2 OF 2
DATE	TITLE	SCALE	
06.10.18	CLAMP	1:1	
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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

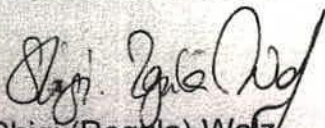
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D2731-1	Lug B31928	3663
50	D3041-1	Lug B31833	3663

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, May 11, 2007

